

Date: Tuesday, 13/01/2009 2:04:20 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG
 Job Number : 44727
 Estimate Number : 13266
 P.O. Number :
 This Issue : 13/01/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run : 38692
 Written By : *JLM 09-01-13*
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-04-16 JLM Verified By:EC

Part Number : D37073
 Drawing Number : UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 20/01/2009 Qty: 6 Um: Each

Additional Product

PRELIMINARY ISSUE



Job Number:



602 d.14
802 ECN 09-502 P

Seq. #: Machine Or Operation: Description :

1.0 MDLRLNB1250X2500 Delrin Bar 1.250"X 2.500"



Comment: Qty.: 0.2363 Ft(s)/Unit Total: 1.4175 Ft(s)

Delrin Bar 1.250"X 2.500"

BATCH: *M107758*

JLM 09/01/13

6

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 2.700" long

JLM 09/01/13

6

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1 HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA738 Rev: *AA* & Dwg D3707 Rev: *U/R*

⑥

2-Deburr per dwg D3707

DIP 09/01/14

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 09/01/14

⑥

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JLM 09-01-15

⑥

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 44727

Part Number: D37073

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

09-01-15

7.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



WF 09-01-15
POSITIVE RECALL
POSITIVE *09.01.16*
AUTH *U*
DATE *09.02.17*

DA&T AEROSPACE LTD		Work Order:	44727
Description: Mounting Lug		Part Number:	D3707-3
Inspection Dwg:	Rev:	Page 1 of 1	

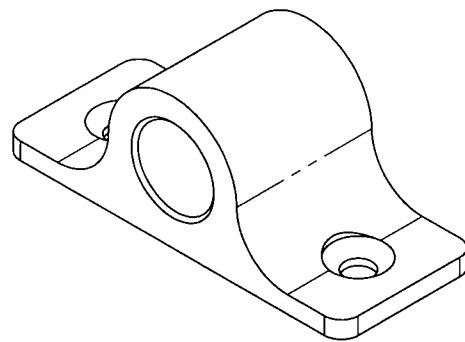
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

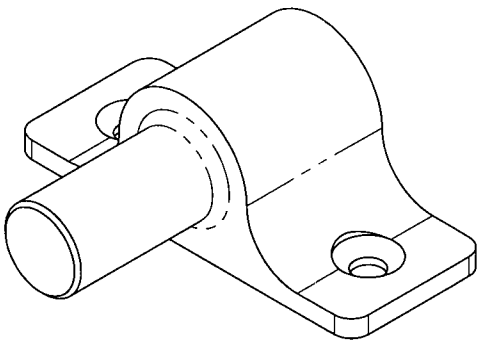
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	± 0.030	2.500	✓			
1.750	± 0.010	1.748	✓			
0.38	± 0.030	0.375	✓			
0.500	± 0.010	0.499	✓			
1.00	± 0.030	1.001	✓			
$\phi 0.201$	$+0.005/-0.001$	0.201	✓			
$\phi 0.385 \times 100^\circ$	$\pm 0.010 / \pm 1/2^\circ$	$0.380 \times 100^\circ$	✓			CSK x 2Pl
$0.03 \times 45^\circ$	$\pm 0.030 / \pm 1/2^\circ$	$0.03 \times 45^\circ$	✓			
$\phi 0.563$	$+0.000 / -0.001$	0.562	✓			
R0.06	± 0.030	0.06	✓			
2.063	± 0.010	2.063	✓			
R0.13	± 0.030	0.13	✓			2Pl
R0.48	± 0.030	0.480	✓			
0.98	± 0.030	0.974	✓			REF
0.500	± 0.010	0.500	✓			
1.250	± 0.010	1.250	✓			
0.125	± 0.010	0.124	✓			
R0.38	± 0.030	0.38	✓			

Measured by: DTP	Audited by: [Signature]	Prototype Approval:	N/A
Date: 09/01/14	Date: 09-01-15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3707-1 MOUNTING LUG



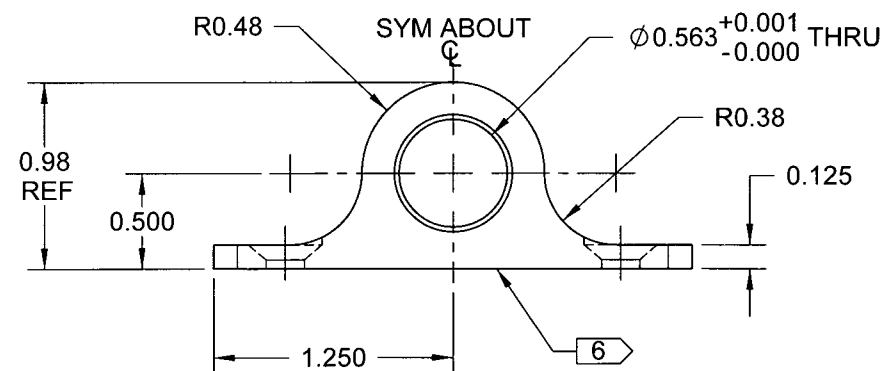
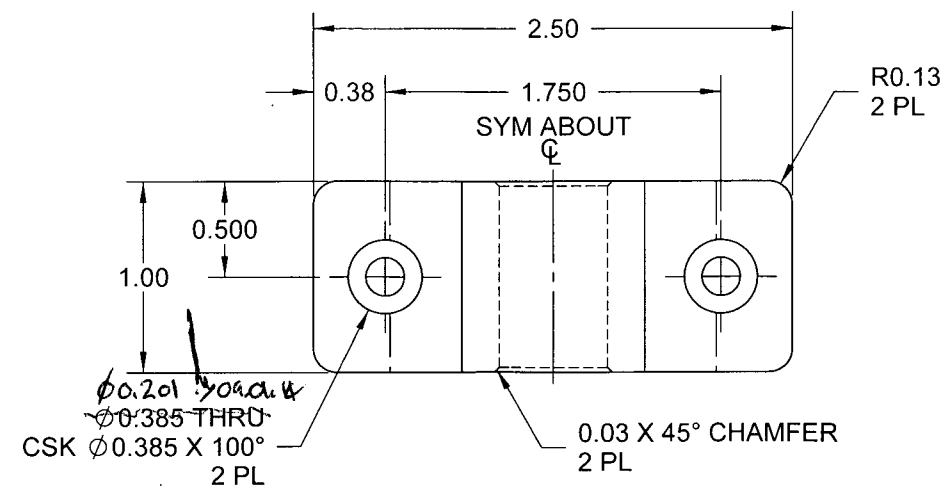
D3707-3 MOUNTING LUG

44727

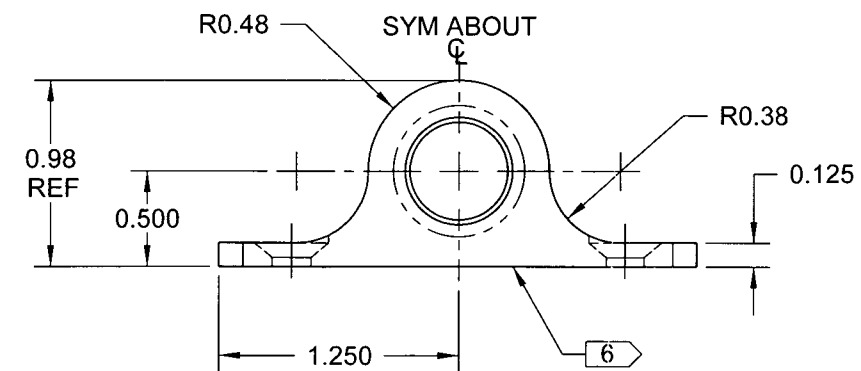
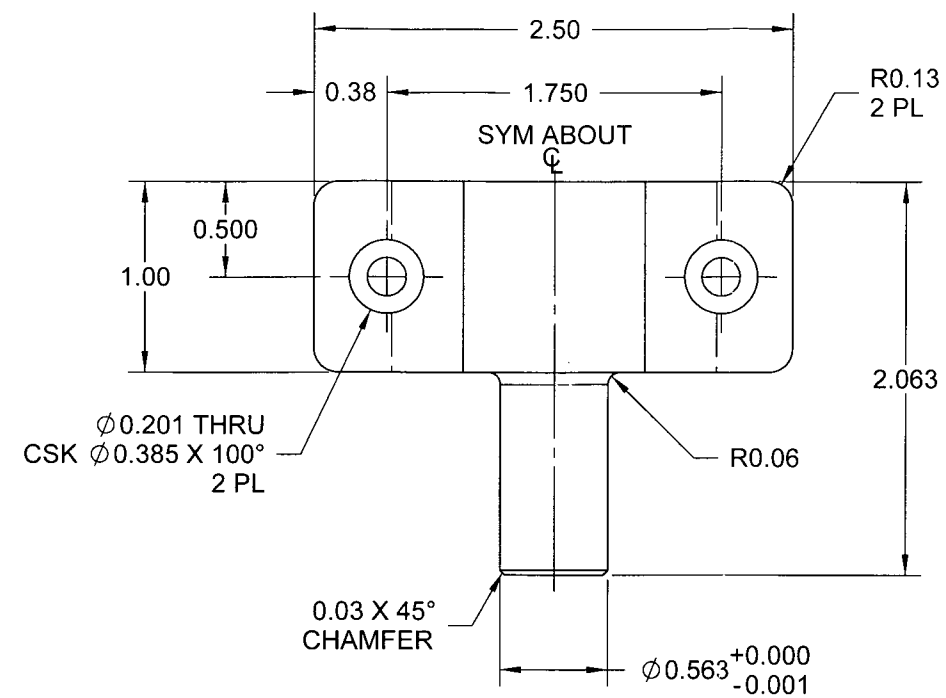
PRELIMINARY ISSUE
b per spec 404-502P
09.06.14

- NOTES:
- 1) MATERIAL: BLACK ACETRON GP ACETAL (REF DART SPEC M-DELRIN-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3707-X" USING VIBRATING STYLUS
 - 7) WEIGHT: D3707-1 = 0.04 lbs APPROX
D3707-3 = 0.07 lbs APPROX

B	UPDATED NOTE 1 (ZN A8-1)	MB	08.08.22
A	NEW ISSUE	MB	08.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3707	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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D3707-1 MOUNTING LUG

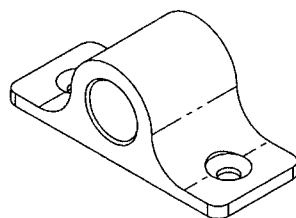


D3707-3 MOUNTING LUG

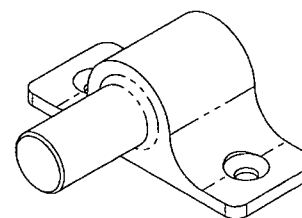
44727
PRELIMINARY ISSUE

Rev. 01-5028
O.A.A. 4

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MFG. APPR.		D3707	SHEET 2 OF 2
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D3707-1 MOUNTING LUG



D3707-3 MOUNTING LUG

44727

RELEASED
07/05/10

NOTES:

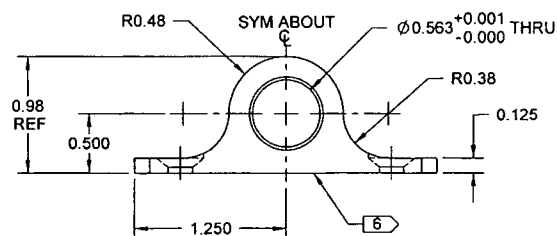
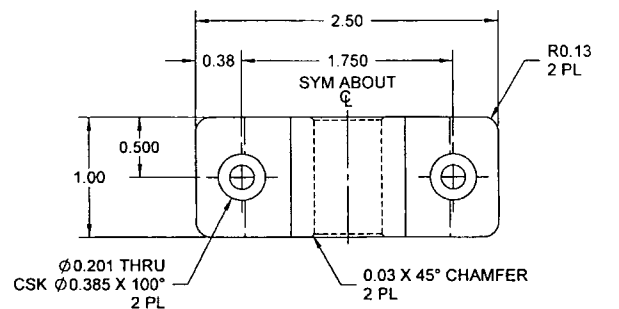
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(REF DART SPEC M-DELIN-B)
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A	NEW ISSUE	MB	08.04.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.22		

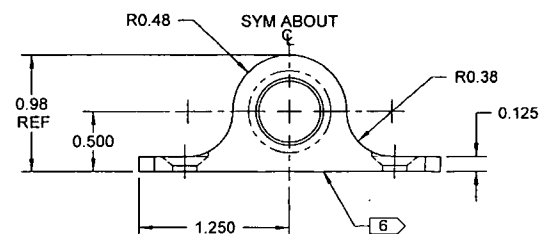
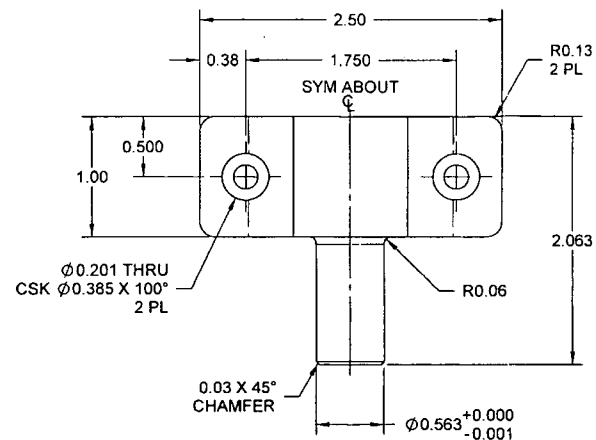
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3707** REV. B
SHEET 1 OF 2
TITLE **MOUNTING LUG** SCALE NTS

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D3707-1 MOUNTING LUG



D3707-3 MOUNTING LUG

RELEASED
69/02/05 MJD

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3707	SHEET 2 OF 2
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DE APPR.		MOUNTING LUG	NTS
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44727